



HIRSCHMANN
AUTOMOTIVE

Handling Manual

**2- to 8-way 1.2 SealStar Male Connector
Generation 2**



**EVS-100121-00
Version 00**



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1. General

1.1 General information and requirements

- a. This process specification describes detailed requirements and guidelines of Hirschmann Automotive on how to assemble the keys and options of the 1.2 SealStar male connectors Gen 2 in order to achieve compliance with the defined product- and process specification.
- b. The customer/manufacturer processing the Hirschmann products is responsible for the appropriate processing of the relevant products and also for the compliance of the described process results with this specification.
- c. In case of improper or deviating processing through the customer/manufacturer, any complaints need to be declined.
- d. During the whole assembly process, individual components and assembly units must not be damaged in any way.
- e. Both the named fixture suppliers and equipment in this process specification are not mandatory to use from Hirschmann Automotive point of view. They are only a non-binding reference which supplier and equipment Hirschmann Automotive used for the evaluation, validation and release of this process specification.
- f. The customer can define different fixture suppliers and equipment for the assembly process at any time.
- g. Additionally, the customer/manufacturer shall validate and release the complete assembly process independently of the chosen equipment supplier.
- h. Process parameters (e.g. welding currents, - times etc.) will not be predetermined by Hirschmann Automotive. In fact, the required technical result of this process needs to be specified in the process specification. With this result, the customer will achieve the product specification conformity (e.g. welding knot geometries, min. retention forces and so on).
- i. All kind of warranty and liability claims of our customers towards Hirschmann Automotive according to the agreed contractual regulations are only valid with reservation of the compliance with the according process specification.



1.2 Applying relevant Information/Documentation

Customer drawings Hirschmann Automotive:

| | |
|--|--|
| 2way 1.2 SealStar MA Connector | 809-555-...00 |
| 3way 1.2 SealStar MA Connector | 809-556-...00 |
| 4way 1.2 SealStar MA Connector | 809-557-...00 |
| 8way 1.2 SealStar MA connector | 809-560-...00 |
| „Deutsche Norm“ DIN EN 60352-2 | solderfree electrical connection part 2: crimp connection |
| MLK 1.2 contact pin (Kostal) | 10322345-1 |
| Processing Specification (Kostal) DOC00061540 | Mini lamina contacts MLK 1.2 |
| TAB contact 1.2mm (TE) | C-1418754 |
| Application Specification (TE) 114-18464 | MCON 1.2mm Contact System |

2. Delivery Condition / Product Components

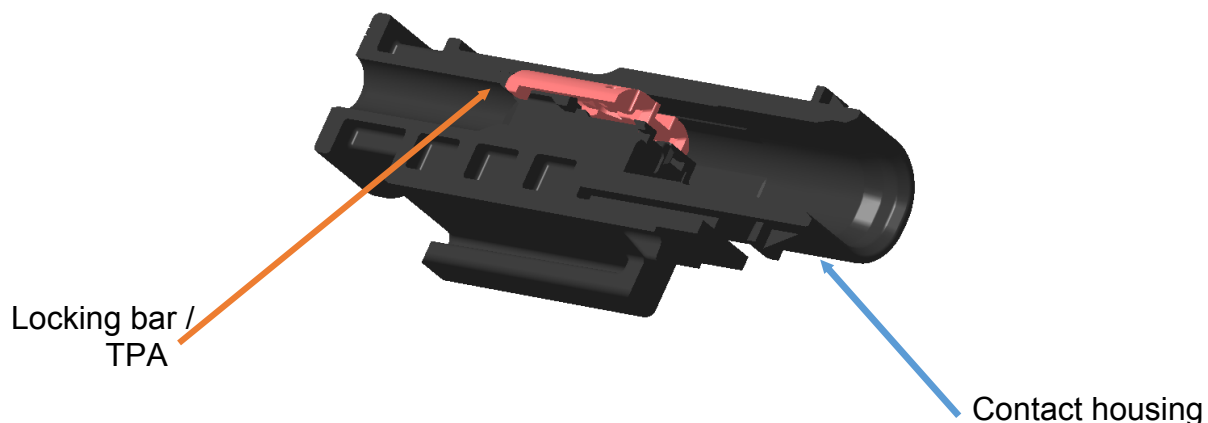
The housings are generally packaged and delivered as bulk goods.

The connector consists of a contact housing and a single locking bar. The general state of delivery has the locking bar in pre-engaged position and the secondary lock or terminal position assurance (TPA) therefore open.

In very rare cases, it may occur that the locking bar moves into final locking position and closes the secondary lock.

In the case of the closed secondary lock, this can be adjusted according to point 5.4 to be returned to the initial state.

symbol image





3. Terminals

Please see terminal manufacturer drawing for processing requirements

To guarantee the required sealing performance the terminals and seals must fit the wire and all open cavities must be plugged with cavity plugs (except if the cavity is pre-flashed).

Crimp tools, e.g. applicators, hand crimp tools and removal tools - please see process specification of the terminal manufacturer.

Only contacts for which a release of the OEM is available may be used. This has to be clarified by the harness maker.

4. Matching protective caps, cover caps, end caps or transport caps

Appropriate mounting parts are available for the housings.

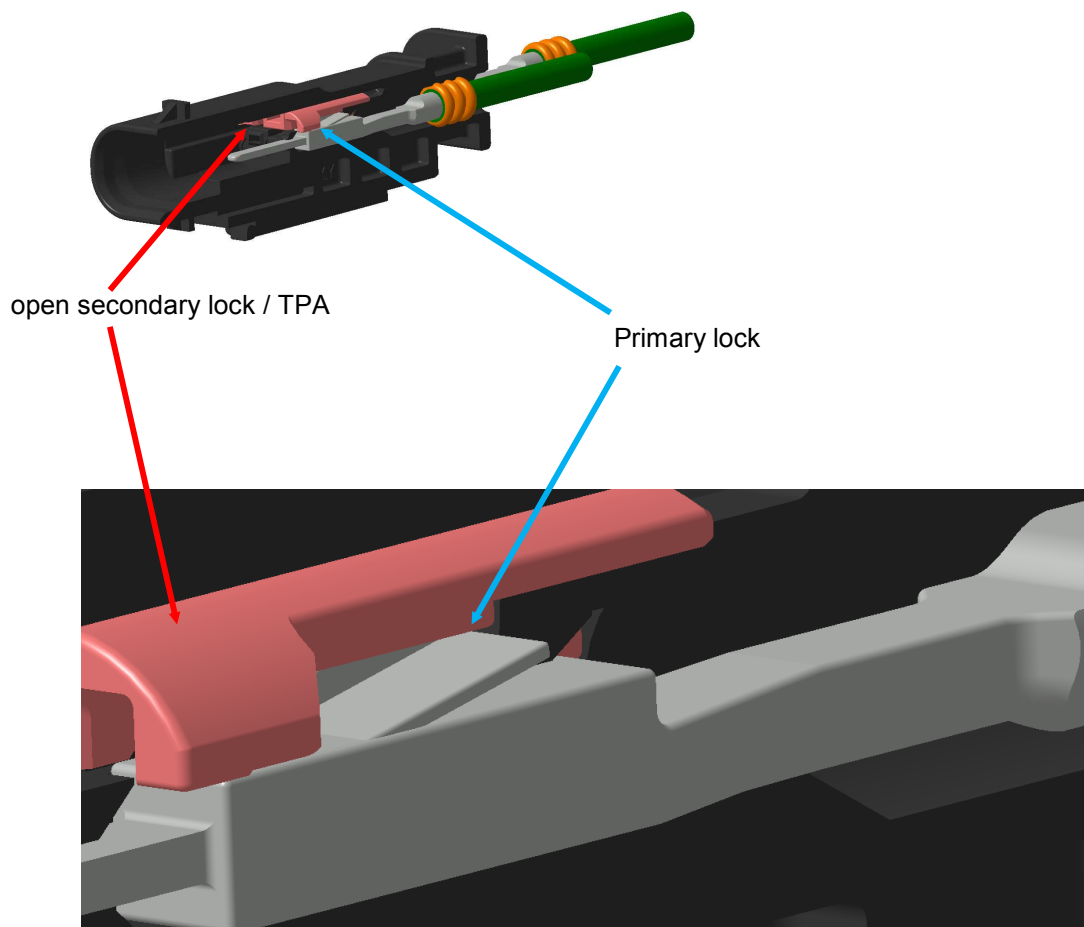
Details on the availability can be found in the customer's drawing or clarified with the respective manufacturers.

5. Insertion and Removal of Terminals

5.1 Primary Lock

The connector is delivered ready for assembly.

The contacts will be inserted in the connector until a click is audible.



Tool for opening the primary lock and disassembling the contacts available from MIBO-Stahl.

MIBO-Stahl part number: **96609**

5.2 Secondary Lock/ TPA

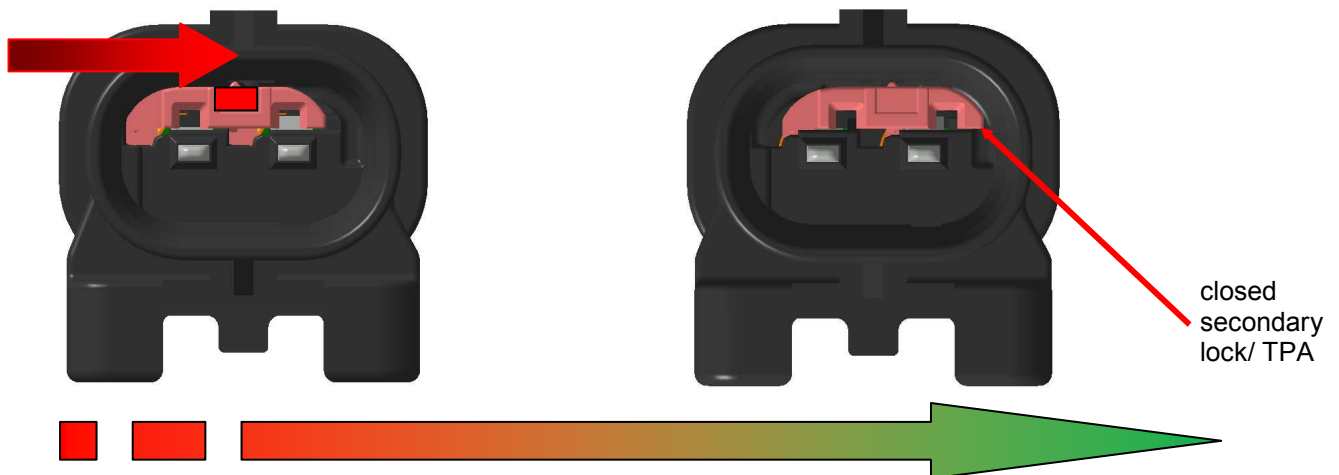
After the terminals are inserted into the contact carrier (primary lock active), the secondary lock/ TPA must be activated by sliding the locking bar into end position. To move the TPA, only the **red marked gap** may be used. A uniform force distribution on the **red marked gap** parallel to the direction of displacement is to be ensured. By multiple available gaps only one has to be used to move the TPA.

The slider should be moved until a click can be heard.

The maximum operating force of the slider is 50N.

Please mind that the terminals or the sealing area **must not** be touched by any used tool!

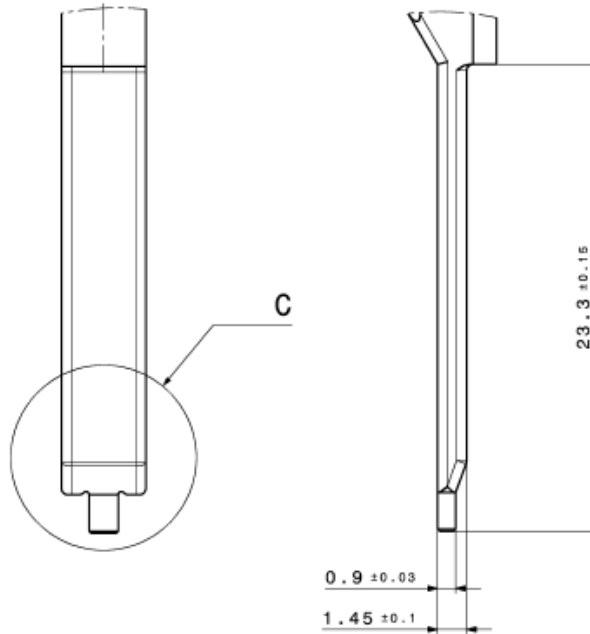
PRESS



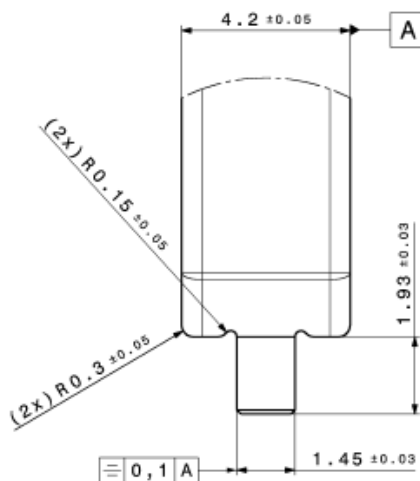
5.3 Proposal for TPA moving tool

The tool can be used to move the TPA from delivery to end position and also from end position to delivery condition.

Definition and part number of moving tool by MIBO-Stahl: **16230**



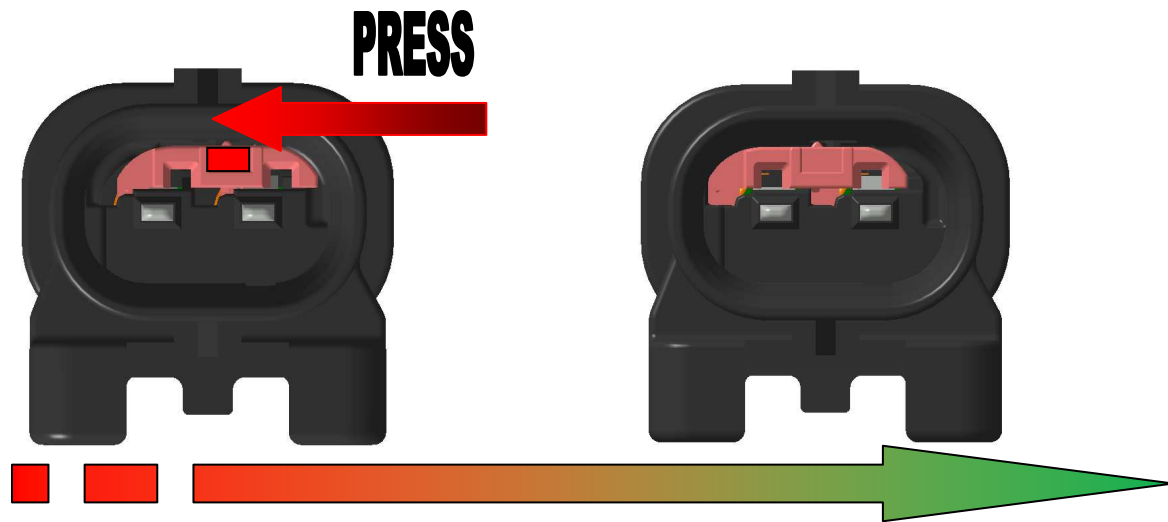
Detail C
Maßstab: 8:1



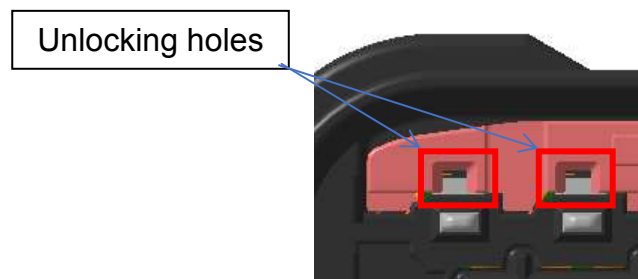
5.4 Removing of the 1.2 Terminal

The contacts can be removed for repair. Therefore the TPA has to be deactivated by sliding it into the delivery condition.

Again the sealing area must not be touched!

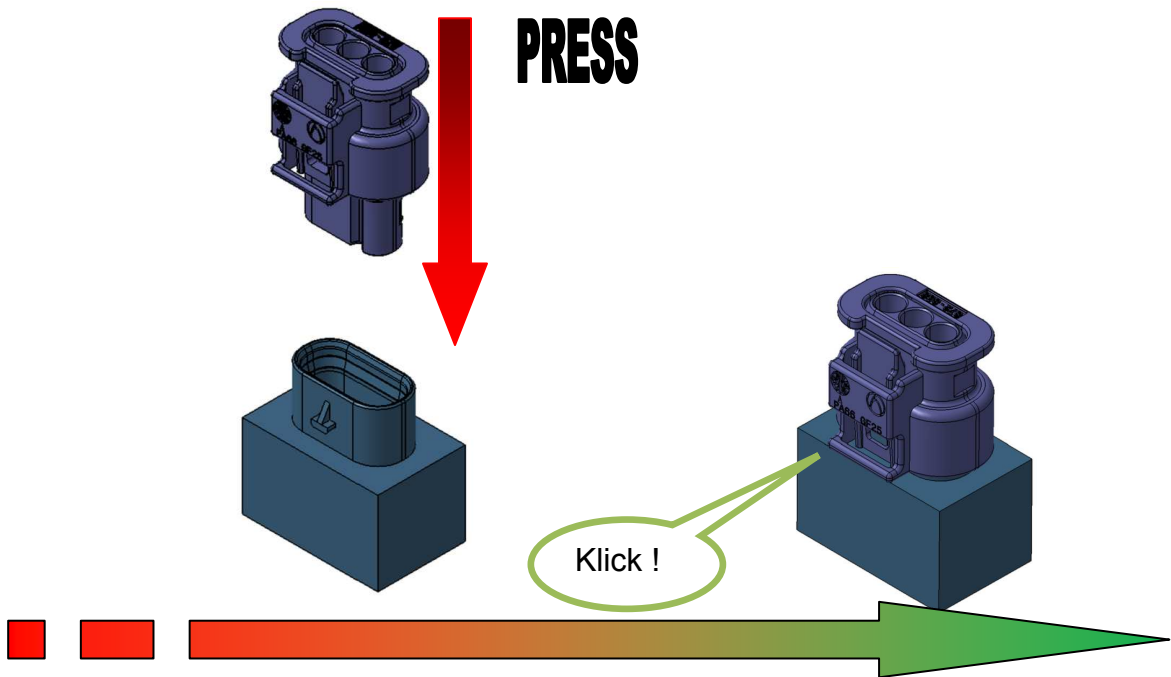


The primary lock of the terminal can be opened and the terminal can be removed (following the process specification of the terminal manufacturer).

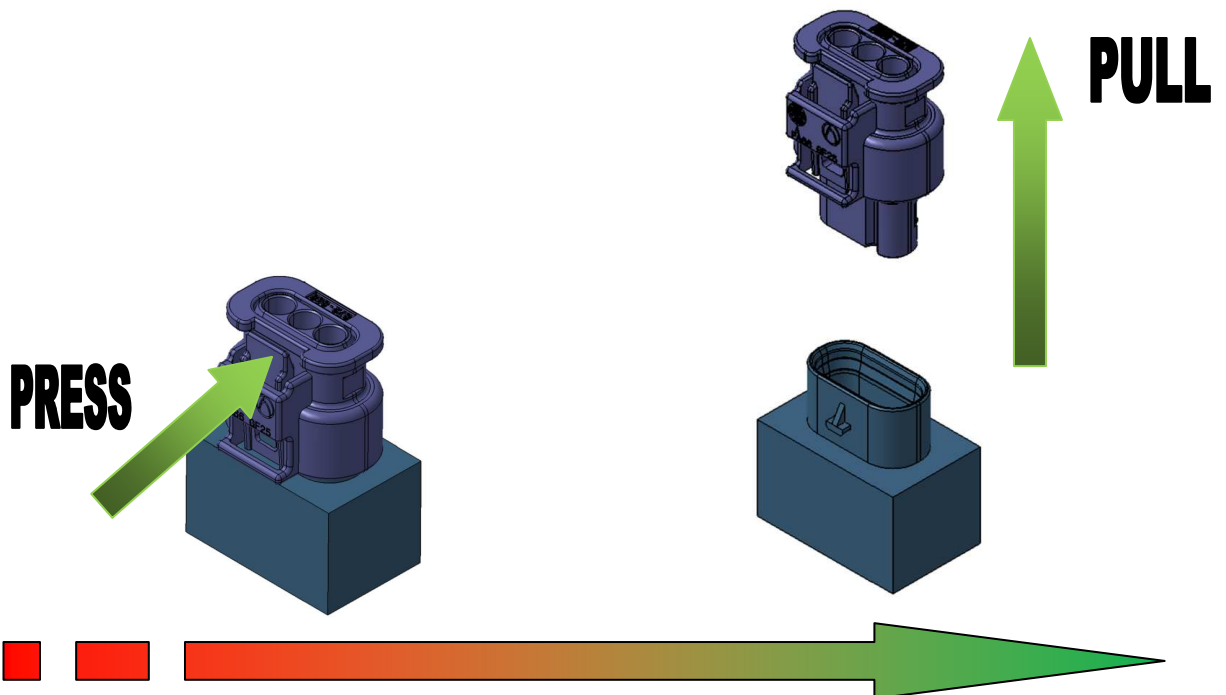


6. Connect and disconnect of a Connector

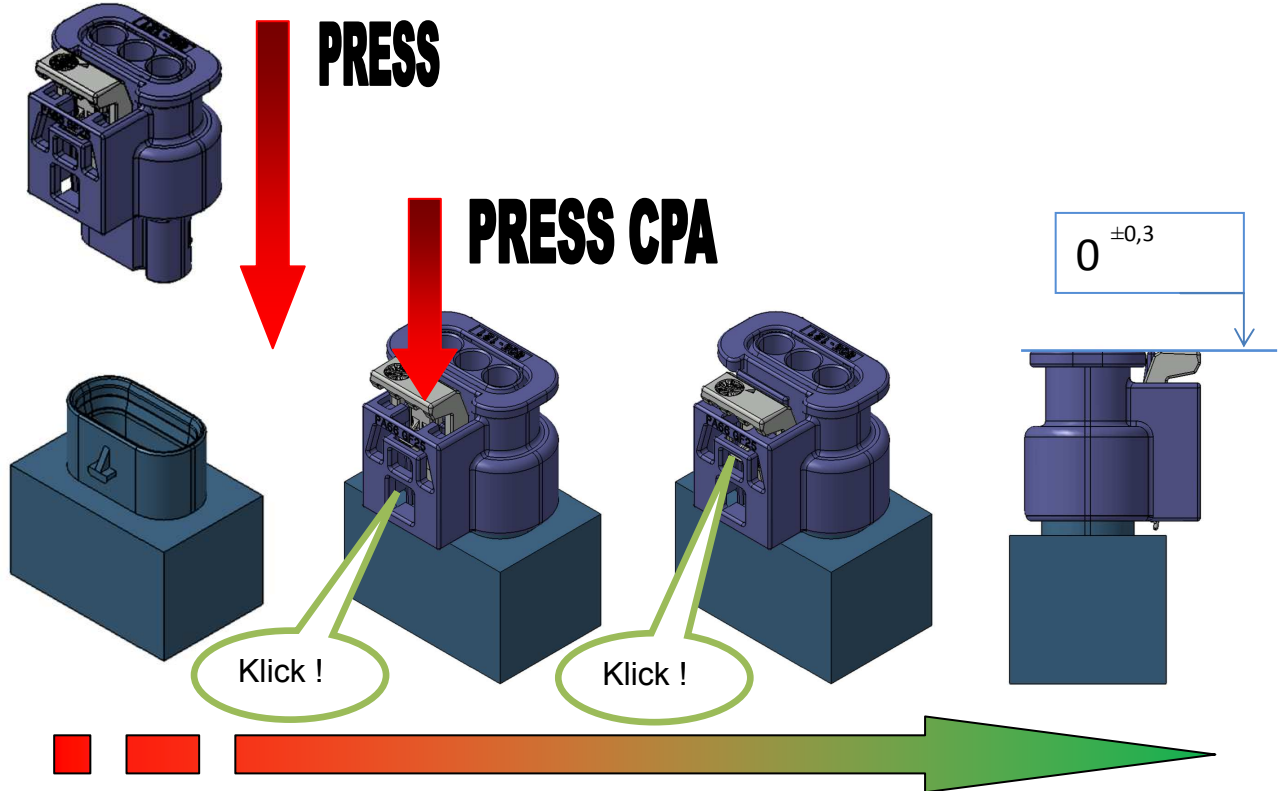
6.1 Connection the female housing without CPA



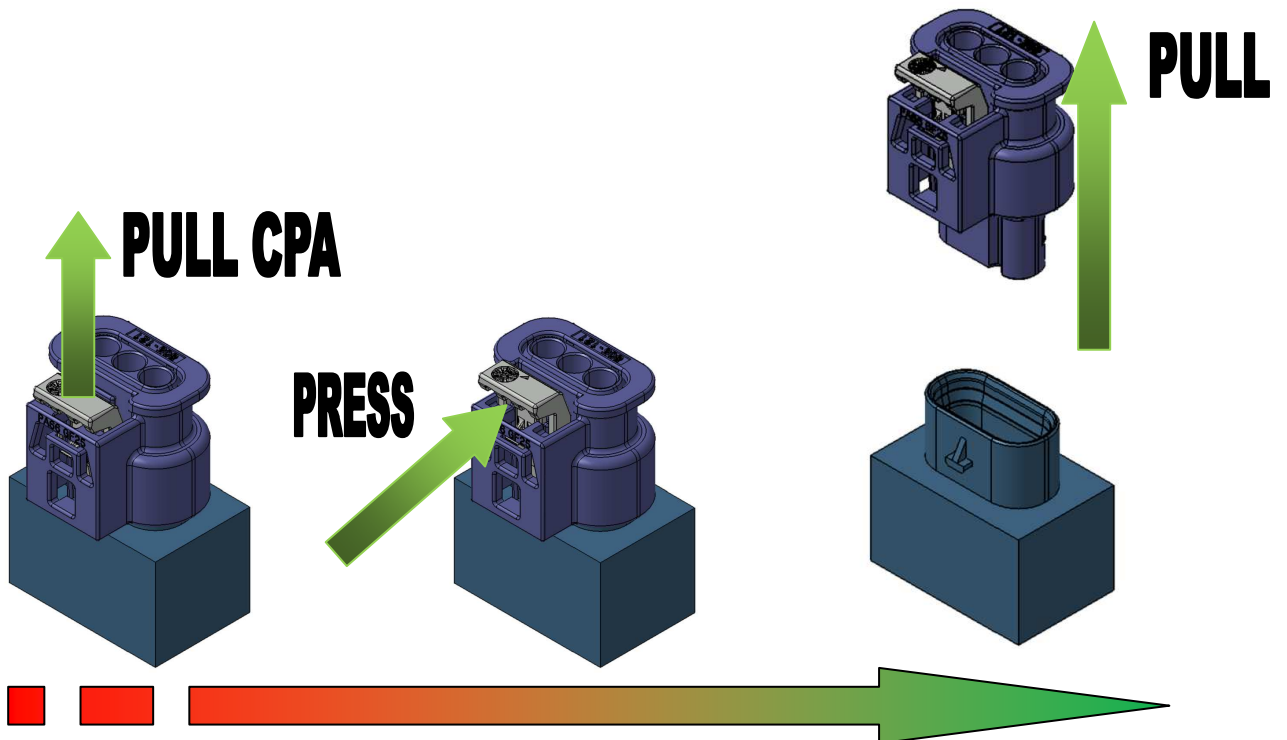
6.2 Disconnection the female housing without CPA



6.3 Connection the female housing with CPA



6.4 Disconnection the female housing with CPA





7. Index change table

| Version | Index | Editing |
|----------------|---------------|----------------|
| 00 | first edition | Außerer |
| | | |